

Date: Monday, 12/01/2009 2:31:13 PM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|----------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | MAINTENANCE STEP, RH |
| Job Number : | 44580 | | |
| Estimate Number : | 11284 | | |
| P.O. Number : | | Part Number : | D3436044 |
| This Issue : | 12/01/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3436 REV A |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 42288 | Drawing Revision : | A |
| Written By : | | Material : | |
| Checked & Approved By : | JUD 09.01.12 | Due Date : | 30/01/2009 |
| Comment : | EsT A 05.05.11 New Issue KJ/JLM | Qty: | 4 |
| | | Um: | Each |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D34361

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1 D3436-1 Clamp

B44785 → 1✓
 B42321 → 3✓

Pl 09.01.26

2.0

D34364

Right Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

RH Step

Pick:

Qty Part Number Description Batch

1 D3436-4 RH Step

B44786*

Pl 09.01.26

3.0

D34365

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

4 D3436-5 Bushing

B23357✓

Pl 09.01.26

4.0

D34367

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1 D3436-7 Cap

B42323✓

Pl 09.01.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:31:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 44580

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M100075

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M19317

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M100075

~~WING WALK K 01-109917~~

CP 09-01-26
BR 09-01-27

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

1-Slit part D3436-041 on bandsaw as per Dwg D3436

2- deburr

CP 09-01-26

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BF 09-01-26 (4x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09/01/26 (4x) (4x)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME: 8:00

OVEN TEMPERATURE: 400°

FINISH TIME: 8:30

FL 09/01/27

WING WALK M109917

BR 09-01-27 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, RH

Job Number: 44580

Part Number: D3436044

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/27

(2)

11.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description

2 D3436-9 Pad

A/R N/A Contact Cement

Batch

B42324 (42)

B42414 (42)

M109109

09/01/27 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/27 (42)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2792

09/01/27 (4)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27

Job Completion



09/01/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

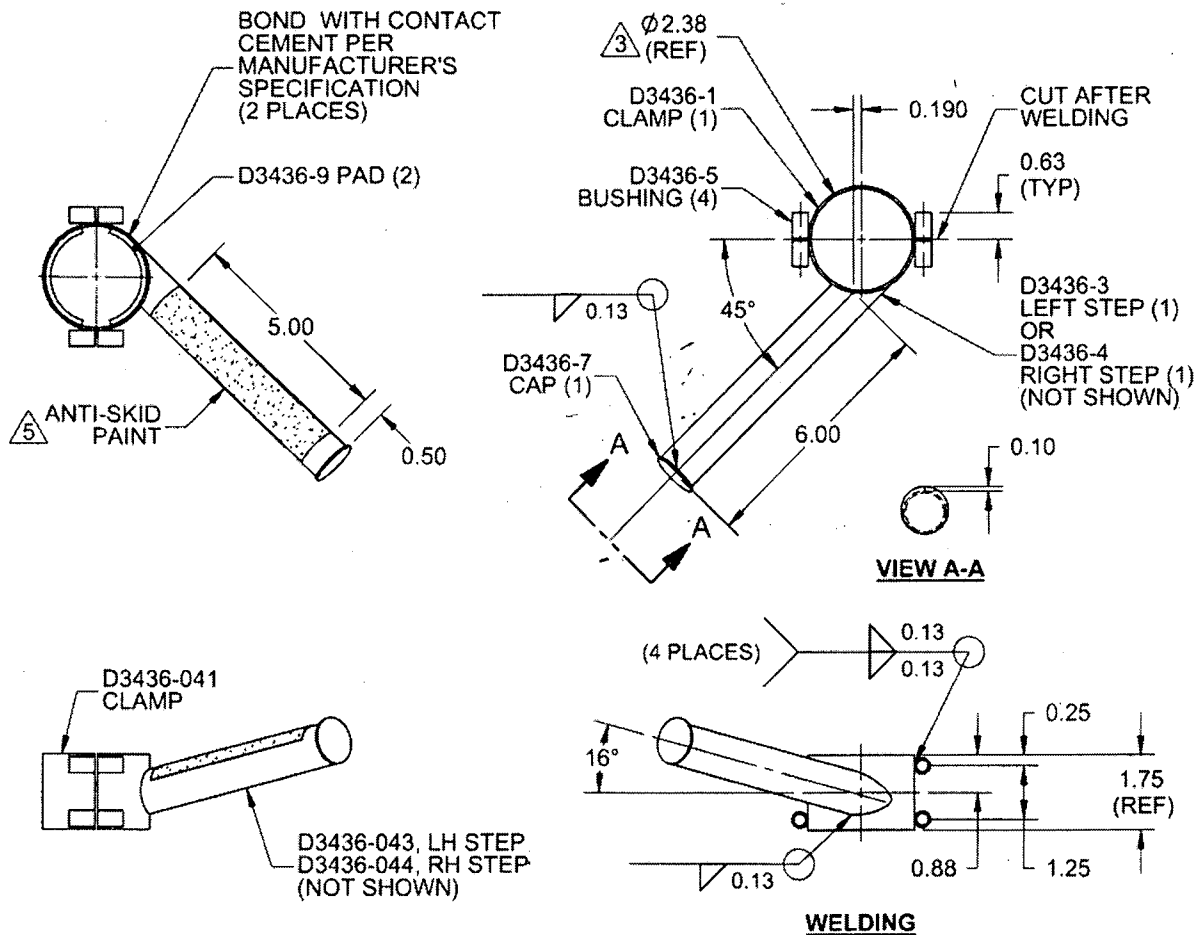
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|----------------------------------|--|------------------------|
| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED /// | APPROVED /// | DRAWING NO. D3436 | REV. A SHEET 1 OF 4 |
| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SCALE 1:4 |
| A | 05.04.28 | NEW ISSUE | |

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

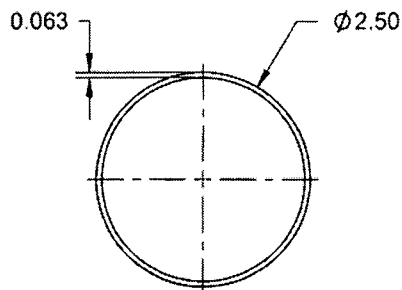
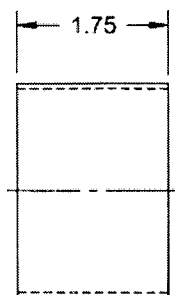
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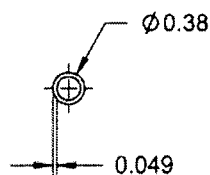
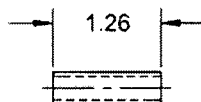


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| CHECKED # | APPROVED # | DRAWING NO. D3436 | REV. A SHEET 2 OF 4 |
| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SCALE 1:2 |



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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05-05-27

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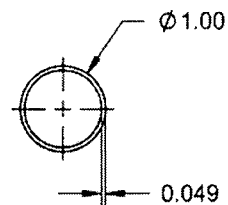
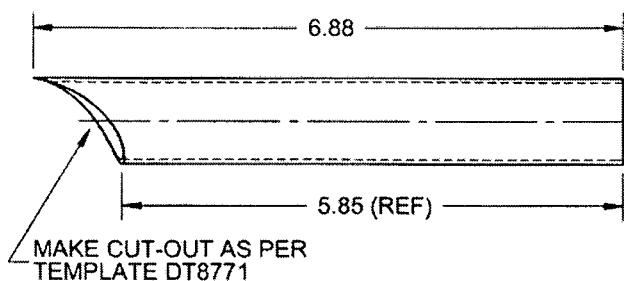
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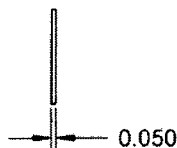
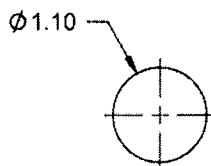
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| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SCALE 1:2 |

**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

D3436-3/ -7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 #

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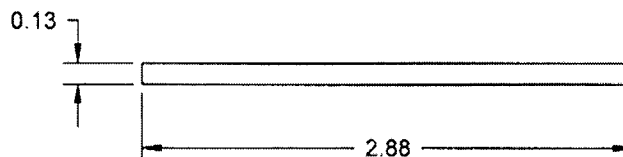
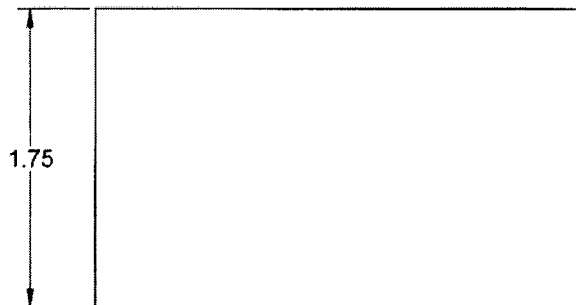
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3436 | REV. A SHEET 4 OF 4 |
| DATE 05.04.28 | TITLE MAINTENANCE STEP | | SCALE 1:1 |



RELEASED

05-05-27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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